



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3179-041
Job Sheet 199793

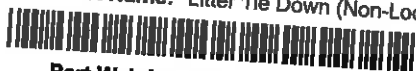


Part No: D3179-041

Part Name: Litter Tie Down (Non-Locking)

Job Qty: 10 pcs

15 pcs. D.A



Part Weight: 0 lbs

Job Created: 9/3/19

Due Date: 9/17/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Bandsaw - 1	10 pcs	9/17/19	9/17/19	0.00	0.83	Bandsaw - 1	68-6	79 19/10/07
110	HAAS 4 Axis - B4B	10 pcs	9/17/19	9/17/19	0.37	18.18	HAAS - 1 - B4B	52 14/10/07	
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs	9/17/19	9/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS	
							QC 2 - 52	52	
							QC 2 - 57	9-89	19/10/07



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Container No: S220015



Part: D3179-041

Job No: 199793

Serial No/Batch: S220015

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/04/19

130 QC 8	10 pcs	9/17/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mml 19/10/07
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	9/17/19	0.00 0.81	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	OCT 08 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	

						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
						QC 7 - 10	
150 QC 7	10 pcs	9/17/19	0.00	0.00		QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
160 Powdercoat - 1 White Gl(A)- B4B	10 pcs	9/17/19	0.00	0.60		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
170 QC 3	10 pcs	9/17/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	

BR 19-10-8.

BR 19-10-8.

160 Powdercoat - 1 White Gl(A)- B4B
 11/19/19
 START: 12:55 O.T. 30 FINISH: 1:25

					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	DAS OCT 0 9 2019
					QC 3 - 58	58
					QC 3 - 59	9.89
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Small Fab - 2 - B4B	10	9/17/19	0.00 1.49	Small Fab - 1 - B4B	DAS OCT 0 9 2019
	pcs				Small Fab - 2 - B4B	58
					Small Fab - 3 - B4B	9.89
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
190	QC 5	10	9/17/19	0.00 0.00	QC 5 - 10	
	pcs				QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS
					QC 5 - 61	61
					QC 5 - 81	9.89
200	Packaging 3-1 - Stock - B4B	10	9/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9.89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	10 pcs	9/17/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9:59

OCT 10 2019

Part Op 100 - (Bandsaw) Cut blanks: 12.150" long

Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA297 Rev: E & Dwg D3179-1 Rev: _____

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Assemble as per Dwg D3179

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	10.1250 ft (1.0125 ea)	100-Bandsaw - 1	519 36 13 14
D2372	Quick Release	20 pcs (2 ea)	180-Small Fab - 2 - B4B	519 36 13 14
D2444	Pip Pin Assembly	10 pcs (1 ea)	180-Small Fab - 2 - B4B	519 36 13 14
MS21042L3	Nut	10 Ea (1 ea)	180-Small Fab - 2 - B4B	5211533
MS27039-1-13	Screw	10 Ea (1 ea)	180-Small Fab - 2 - B4B	50711833
NAS1149D0332J	Washer	30 Ea (3 ea)	180-Small Fab - 2 - B4B	5178378
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	10	39	0
180-Small Fab - 2 - B4B	D2372	20	94	0
	D2444	10	27	0
	MS21042L3	10	1,428	0
	MS27039-1-13	10	370	0
	NAS1149D0332J	30	2,293	0
Part Specifications				
Specifications could not be found.				

Plex 9/3/19 7:37 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 199793
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179 Rev: E		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	0.999	✓		V _{air}	
R0.40	+/-0.030	R.0.40	✓		R.G.	
R0.38	+/-0.030	R.0.38	✓		R.G.	
1.70	+/-0.030	1.70	✓		H.G.	
Ø0.191	+0.005/-0.001	Ø0.191	✓		G.P.	
10.500	+/-0.010	10.500	✓		H.G.	
4.250	+/-0.010	4.250	✓		H.G.	
Ø0.246	+0.005/-0.001	Ø0.246	✓		G.P.	
1.50	+/-0.030	1.499	✓		V _{air}	
0.750	+/-0.010	0.748	✓		V _{air}	
1.000	+/-0.010	1.000	✓		V _{air}	
4.00	+/-0.030	3.999	✓		V _{air}	
1.00	+/-0.030	1.00	✓		H.G.	
1.38	+/-0.030	1.39	✓		H.G.	
1.875	+/-0.010	1.875	✓		H.G.	
2.125	+/-0.010	2.125	✓		H.G.	
2.88	+/-0.030	2.850	✓		V _{air}	
3.31	+/-0.030	3.312	✓		H.G.	
R0.375	+/-0.010	R0.375	✓		R.G.	
R0.50	+/-0.030	R0.5	✓		R.G.	
Ø0.191	+0.005/-0.001	Ø0.191	✓		G.P.	
R0.25	+/-0.030	R0.250	✓		R.G.	
R0.375	+/-0.010	R0.375	✓		R.G.	
R0.38	+/-0.030	R0.380	✓		R.G.	
12.00	+/-0.030	12.00	✓		H.G.	
9.000	+/-0.010	8.999	✓		H.G.	
7.50	+/-0.030	7.471	✓		V _{air}	
4.50	+/-0.030	4.508	✓		V _{air}	
2.88	+/-0.030	2.876	✓		H.G.	
2.250	+/-0.010	2.250	✓		H.G.	
1.000	+/-0.010	1.001	✓		H.G.	
0.50	+/-0.030	0.50	✓		H.G.	

Measured by: 52 9-89	Checked by: [Signature]	QC Inspector:
Date: 19/10/04	Date: 19/10/07	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ	
D	16.06.08	Dimensions revised per Dwg Rev E	KJ	
E	17.02.16	Dimensions rearranged	KJ	[Signature]